

Work Order ID 110130

December-17-13 9:15:46 AM

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Page 1

Item ID: D3758-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 12/17/13 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3758	Rev A								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 8 0 Ac
 FLOW CNC Waterjet 1-Cut as per Dwg D3758-1 Dwg Rev: A Prog Rev: A 2- 14-02-19
304.032 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 8 0 Ac
 Quality Control 14-02-19

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 8 0 Ac
 Quality Control 14/2/19

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab			DAS		8			14/02/19
Small Fab	Memo	0.00		30					
Small Fab	1- Deburr any rough edges2- Form as per Dwg D3758			9-89					
140		0.00							
140	QC5- Inspect part completeness to step on W/O			DAS		8			
QC	Memo	0.00		27					
Quality Control				9-89					
150		0.00							
150	Small Fab			DAS		8			14/02/28
Small Fab	Memo	0.00		30					
Small Fab	Assemble rubber cushion as per dwg D3758			9-89					

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 27 0.89 14/2/28				8			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST457</u> Memo	0.00 0.00				8x	DAS 28 9-89	14-02-28	
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						14-03-03	

14-03-03

Picklist Print

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Work Order ID: 110130

Parent Item: D3758-041

Parent Item Name: Clamp

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

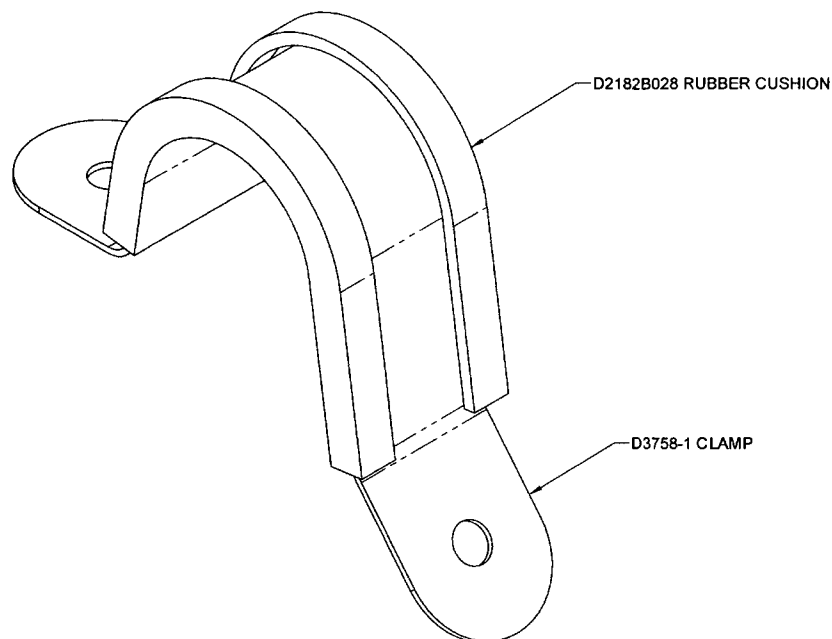
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B028 Rubber Cushion	t.84	Manufactured	No			100	Each	0.0000	1	8			
M304S22GA 304/316 .032 Sheet		Purchased	No			150	sf	441.6300	0.026	0.2189472			

Ac 14-02-19

Location	Loc Qty	Loc Code
MAT020	441.63	
118271	10.76	
120866	54.87	
121889	64.37	
m126593	311.63	

126593 → .22

QTY	P/N	DESCRIPTION
041		
X	D3758-041	CLAMP
1	D3758-1	CLAMP
1	D2182B028	RUBBER CUSHION



D3758-041 CLAMP

110130 MCL
13-12-19

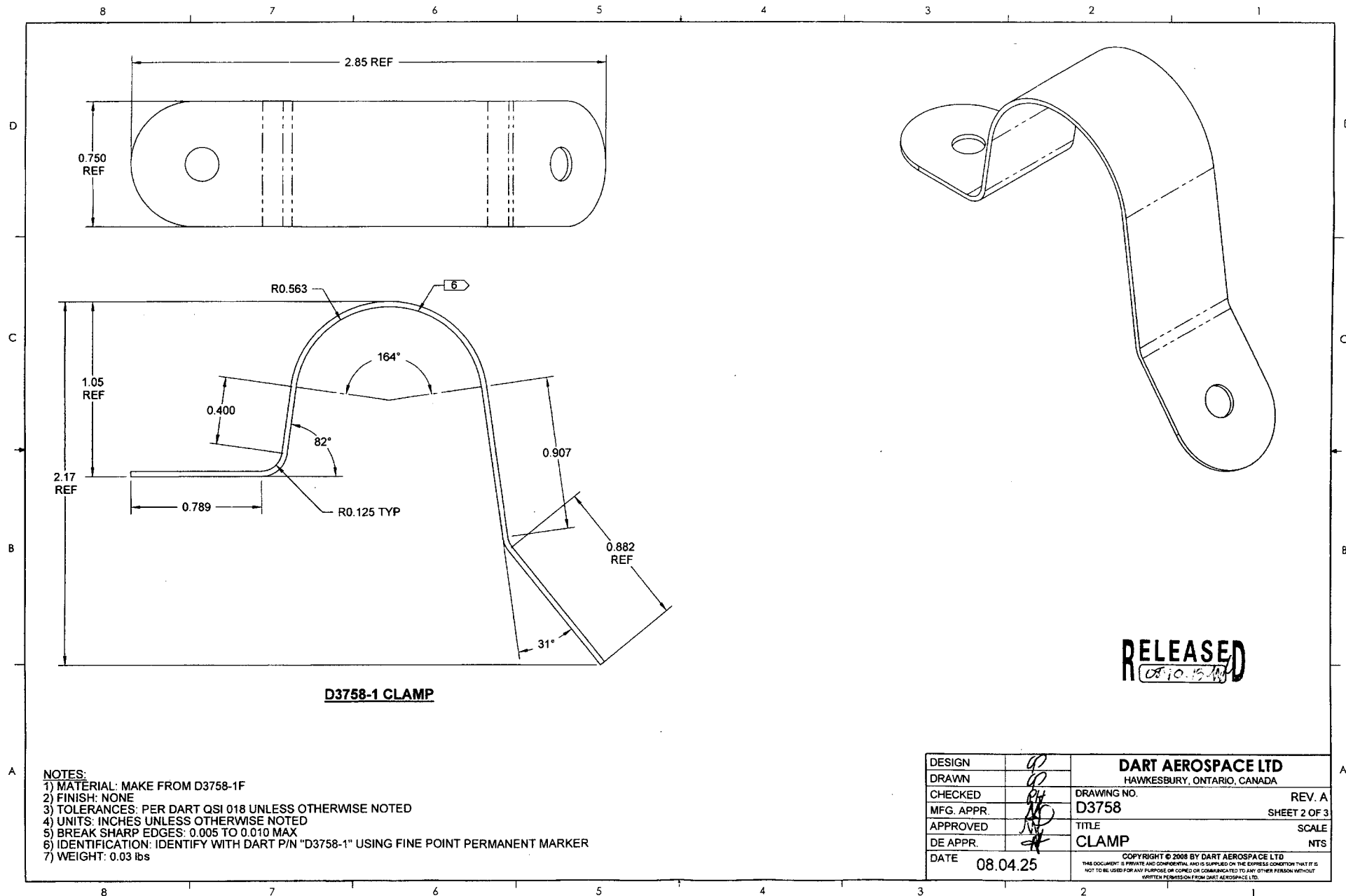
RELEASED
08-10-13-18

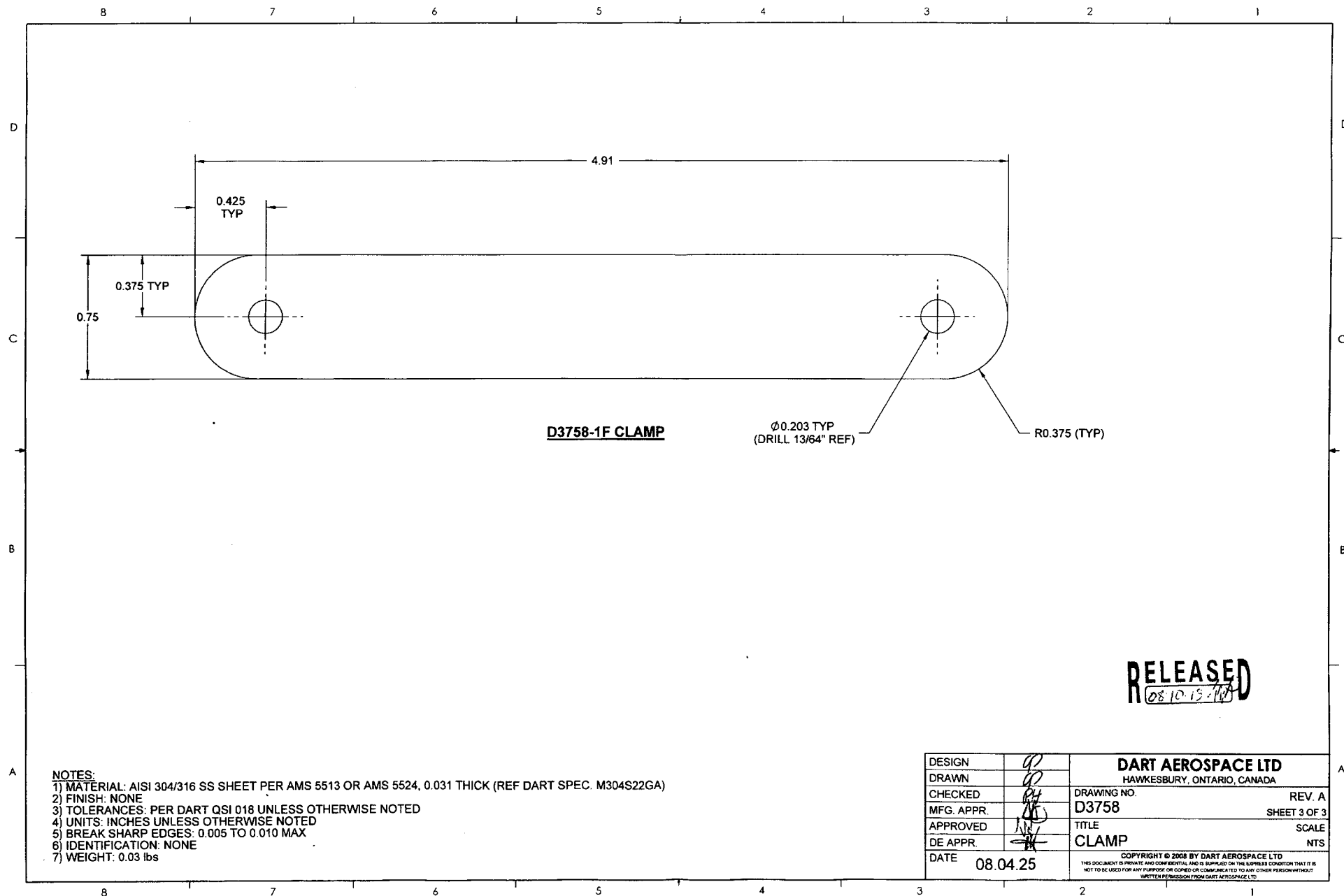
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3758	REV. A SHEET 1 OF 3
TITLE CLAMP	SCALE NTS
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RELEASED
08-10-13-10

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	D	DART AEROSPACE LTD	
DRAWN	D	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3758	SHEET 3 OF 3
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DE APPR.	PH	CLAMP	NTS
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